

Date: Friday, 16/05/2008 8:45:37 AM  
User: Julie Lecocq

Process Sheet



*SPLIT*



Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG
Job Number	: 39315		
Estimate Number	: 10255		
P.O. Number	:	Part Number	: D22301
This Issue	: 16/05/2008 S.O. No. :	Drawing Number	: D2230 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: F
Previous Run	: 39137	Material	:
Written By	:	Due Date	: 30/05/2008
Checked & Approved By	: <i>JUL 08.5.16</i>	Qty:	<i>300</i> Um: Each
Comment	: Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC		



Additional Product


Job Number: 



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
 		
Comment: Qty.: 0.0717 f(s)/Unit Total : 14.3430 f(s) Lug Extrusion D2423 Extrusion Batch: <i>B 33310</i> <i>08/05/20</i> <i>(300)</i>		

2.0	BAND SAW	BAND SAW
 		
Comment: BAND SAW <i>cut at Metec</i> Cut D2423 extrusion to 0.82" Batch:		

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
 		
<i>RG</i> <i>Issue for 6387 Metec</i> Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine per folio D2230-1 (Check for crack while loading into the machine.) 2-Tumble and deburr rough edges after tumbling <i>Machine per drug D2230 Rev.F</i> <i>08/05/20</i> <i>(300)</i>		

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 		
<i>RG</i> <i>Receive &amp; inspect for transit damage</i> <i>Ensure C of C attached</i> Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>08/05/29</i> <i>(85)</i>		

5.0	QC5	SECOND CHECK
 		
<i>RG</i> <i>Inspect level 5</i> Comment: SECOND CHECK <i>08/05/29</i> <i>(485)</i> <i>counters</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Drawing Name: MOUNTING LUG

Job Number: 39315

Part Number: D22301

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Acid etch and Alodine as per QSI 005 4.1

*Handwritten:* 22/ BK 08-05-29 (85)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* counter 08/05/29 (x85)

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING  
Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*Handwritten:* 7:10  
320°  
7:40

*Handwritten:* BK 08-05-30

*Handwritten:* (85)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*Handwritten:* HD

*Handwritten:* 08-05-30

*Handwritten:* (x85)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

*Handwritten:* Rep/30 85

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten:* 08/05/30 (x85)

Job Completion



*Handwritten:* 08/05/30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



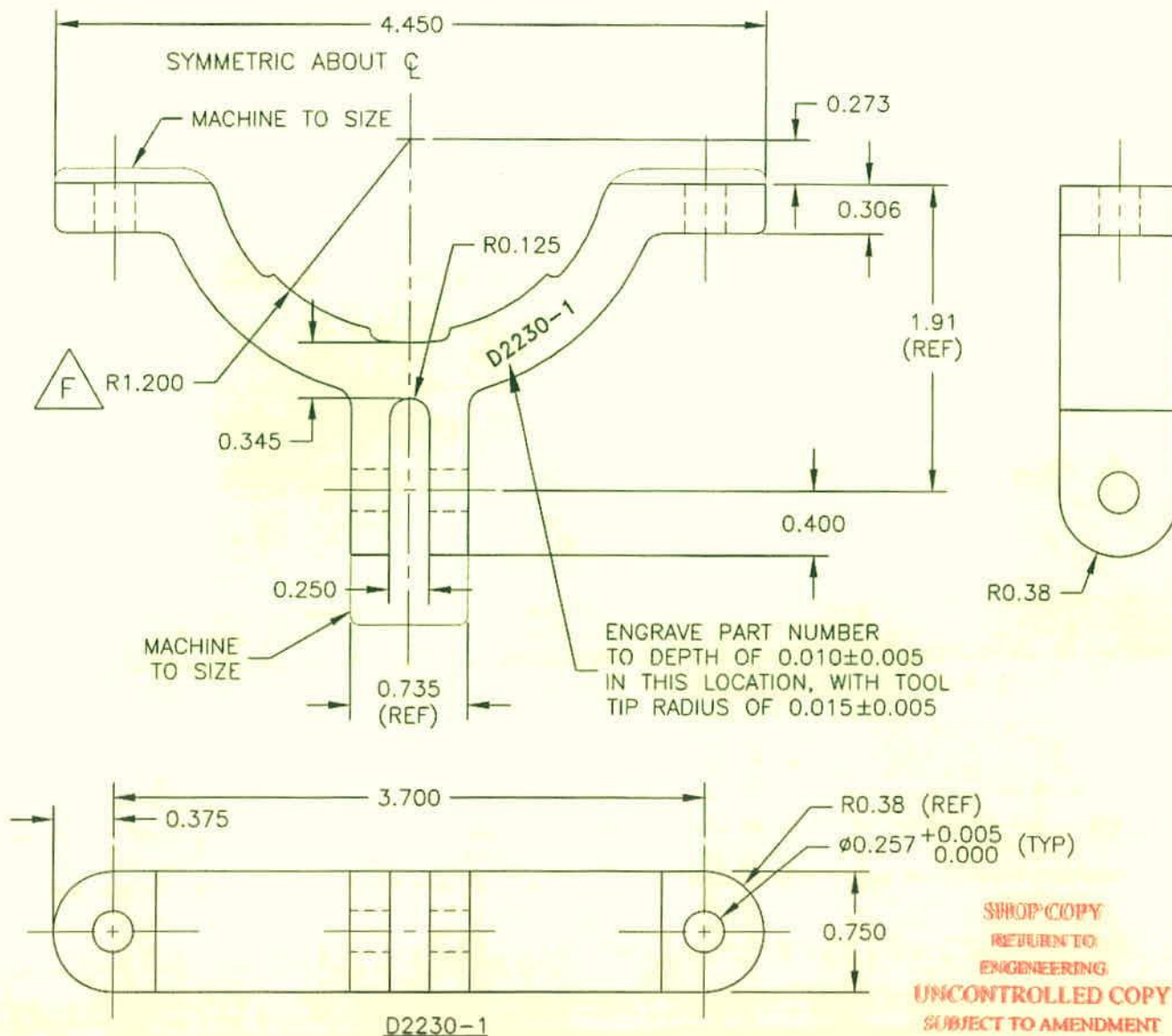






**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. F
		D2230	SHEET 1 OF 2
DATE		TITLE	SCALE
99.12.13		MOUNTING LUG	1:1
C	94.03.30	RE-DESIGN	
D	95.01.04	RE-DESIGN	
E	95.01.04	RE-DESIGN	
F	99.12.13	REDESIGN; R1.200 WAS R1.100	

**RELEASED**  
199.12.21 DS

MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

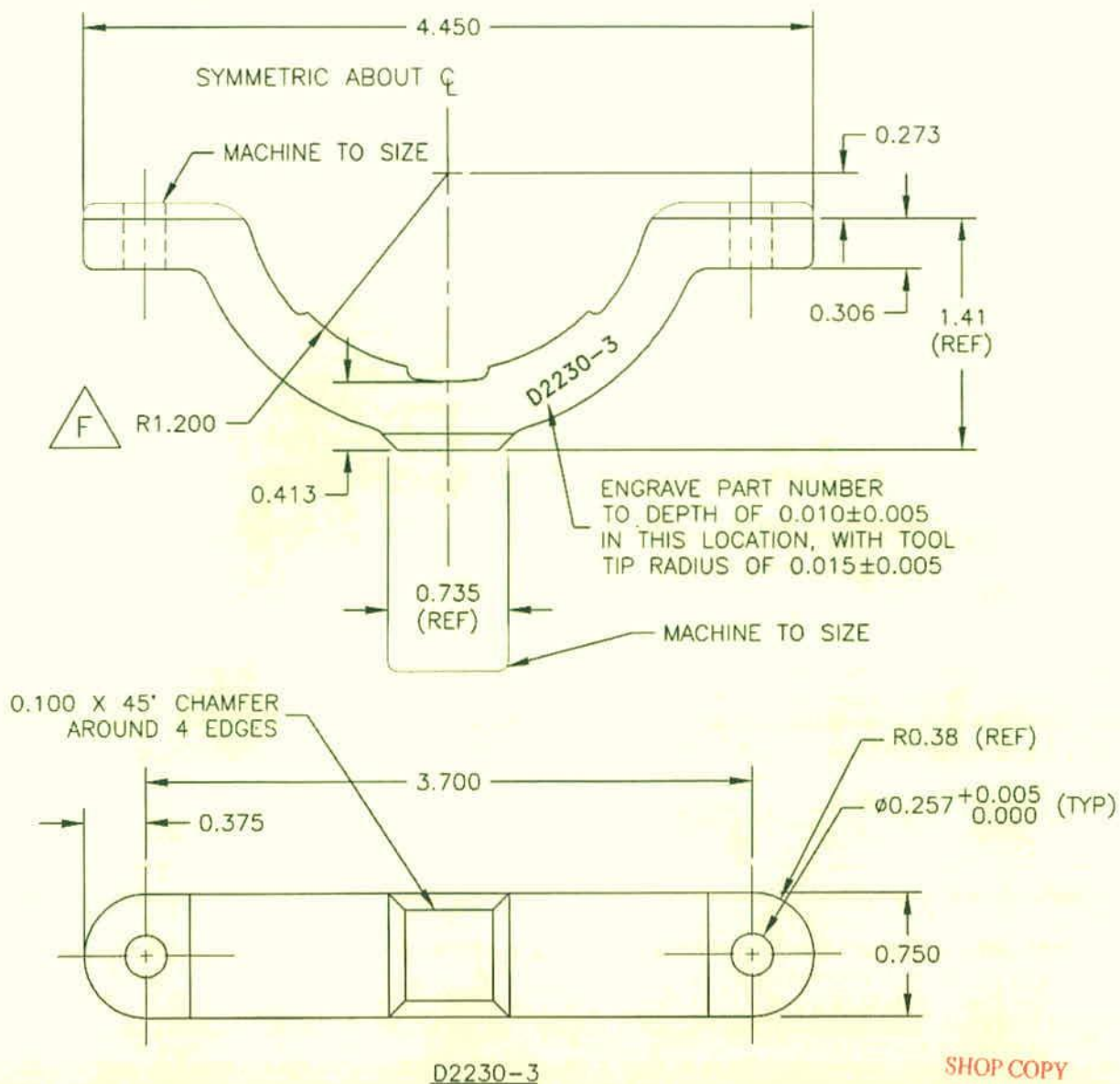
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31315





**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

**RELEASED**  
79.12.21 DS

MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39315

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## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
85	D2230-1	Mounting Lug B39315	6387
MATERIAL: supplied by DART D2423 B33310			

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Denise Robinson", is written over a horizontal line.

Denise Robinson

Vankleek Hill, May 29, 2008

